

Work Order ID 86171

86171

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June 21, 2012 3:17:47 PM

Item ID: D4544-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Extrusion
 Start Date: 6/21/12 Start Qty: 4,524.00 ***4524*** Cust Item ID:
 Required Date: 7/27/12 Req'd Qty: 4,524.00 ***4524*** Customer:
 Reference:

Approvals: Process Plan: CD Date: 12/06/12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4544	

100	PURCHASING	0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O <u>17277</u>								
	a) Extrude as per Dwg D4544								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure material certification is attached								
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control	Ensure Material certification comply to Dwg D6001								

CD 12/06/12 4524
8+

CD 12/7/12 5552
8+

DAS 16
12/9/12

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>MGT 07</u>	0.00							
140									
Packaging	Memo	0.00				5952			
Packaging						5952			DP 12/09/28
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

ML5 12-09-28
 ML5 12-09-28

Picklist Print

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Work Order ID: 86171

Parent Item: D4544-3

Parent Item Name: Extrusion

Start Date: 6/21/12

Required Date: 7/27/12

Start Qty: 4,524.00

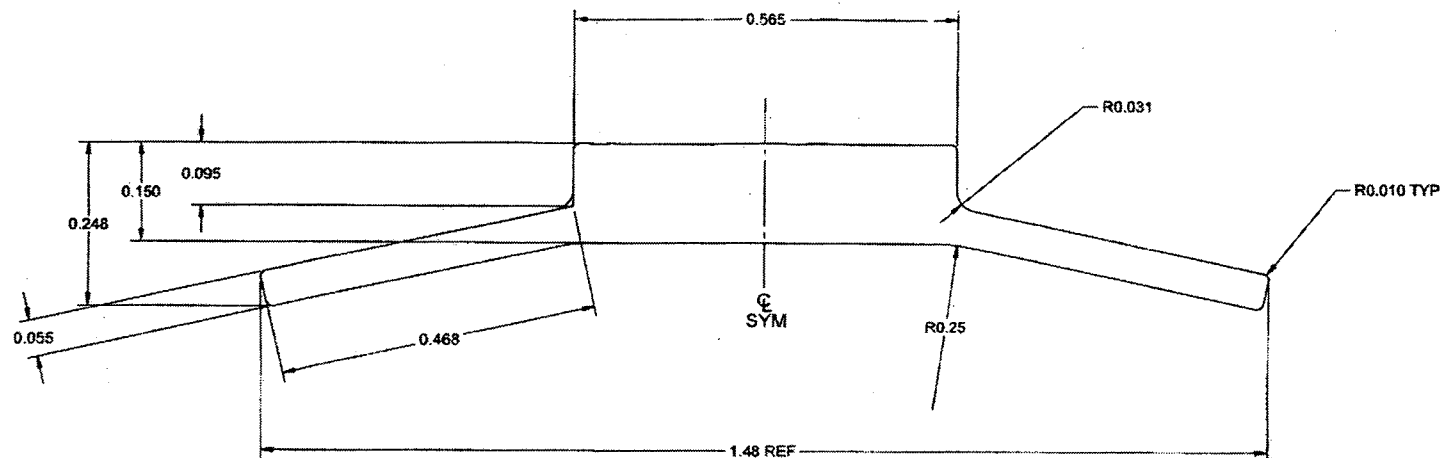
Required Qty: 4,524.00

Comments: IPP REV:A NEW ISSUE 12-06-21 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4544-3P EXTRUSION		Purchased	No				f	0.0000		4524			

6/21/12 550214

SPECIFICATION CONTROL DRAWING



D4544-3-XXX EXTRUSION

C212106121

W10. 86171

NOTES:

1) D4544-3-XXX EXTRUSION

LENGTH

WHERE 'XXX' IS LENGTH IN TENTHS OF AN INCH
EG. 46" LONG EXTRUSION = D4544-3-460

- 2) MATERIAL: 6061-T6 ALUMINUM EXTRUSION PER
QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.0137 lb/in
- 8) NO TOOLING ID MARKS

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4544	REV. B
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, CENTER	NTS
DATE	12.04.20	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD ALL INFORMATION IS PROPRIETARY AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
2012-05-07
2012-05-07

ACCT# 46024

INVOICING AND COMPANY LOCATION

SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

SHIPPING MANIFEST

SHIP TO / EXPÉDIÉ À DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA PHONE: 613-632-5200				SOLD TO / VENDUE À DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA PHONE: 613-632-5200				TERMS / FREIGHT PP		REFER TO THESE NUMBERS ON ALL CORRESPONDANCE REFEREZ-VOUS A CES NUMEROUS POUR TOUTE CORRESPONDANCE		MANIFEST DATE / DATE DU BODEREAL 07-16-12	
CUSTOMER ID / ID DU CLIENT 46024		ORDER DATE / DE LA COM 06/22/12		CUSTOMER PO NUMBER / CLIENT PO Nombre 17277				LOCATION PIC		TRAILER NUMBER / REMORQUE Nombre 5302		SALES REP / REP. DES VENTES G.ATTENBOROU	
BILL OF LADING NUMBER / NO. DE CONNAISSEMENT 006677		JOB / FICHIER				SALES MAN / VENDEUR 042		CREDIT REP / REP DU CRÉDIT		FIELD SALES REP / REP REGIONAL DES VENTES G.ATTENBOROU		CUST SERVICE REP / REP. SERVICE CLIENTELE DLB	
ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO	ALLOY & TEMPER / ALLIAGE & TEMPER	FINISH DESCRIPTION / DESCRIPTION DE FINITION	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison		
001	737 LB			DAA-8-1	6061 T6		1	924	910	LB			
	334 KG				144.0000 IN			419	413	KG			
	377 PC				Cut(+): 0.1180 Cut(-): 0.0000	Min: -10 % Max: 10 %			496	PC			
							814174 / 148414	1	924	910	496 PC		

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

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DATE OF DELIVERY

DRIVER

1	924	910	LB
	419	413	KG
		496	PC
TOTALS			

1850 CLEMENTS RD
PICKERING, ON L1W 3R8

Cust PO#	17277	D/E NO	006677	814174	07/16/12
Ship To					
Sold To			46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA		
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA					
Item No	Part No	Item Description	Cust Part		
001	DAA-8-1	12FT MILL 6061 T6			
Gross Weight	924 LBS	1 PKG			
Net Qty	910 LBS	496 PCS			
Specification		Die Desc			
AMS-QQ-A-200/8 & ASTM B221-08					

Mechanical Tests:

Sn 60126

Tensile	Yield	% Elongation	Conductivity	HRE
MPA / KSI	MPA / KSI		N/A	
332.5 / 48.2	306.9 / 44.5	13.5	N/A	95

Chemical Analysis:

SI	FE	CU	MN	MG	CR	ZN	TI	V
0.62	0.24	0.22	0.07	0.87	0.05	0.09	0.02	0.01

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta, Director of Quality Signature Aluminum Canada Inc